# Work Order ID 52845



*October 15, 2009 12:36:58 PM*

**Item ID:** D2666-2 **Accept** **Setup Start** **Stop**

**Revision ID:** D

**Item Name:** Saddlle, RH Fwd Aft In 206

**Start Date:** 15/10/2009 **Start Qty:** 6.00 **Cust Item ID:**

**Required Date:** 27/10/2009 **Req'd Qty:** 6.00 **Customer:**

**Reference:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** RH **Date:** 09-10-15 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|

| Draw Nbr | Revision Nbr |
|---|---|
| D2666 | Rev D |

100 0.00

HAAS 1

HAAS CNC VERTICAL MACHINING #1

HAAS CNC vertical machine #1

0.00

**Memo**

Program batch number.☐1-Inspect part number and batch number are programmed correctly.☐4-Machine Step No 1 of Folio and visualy inspect as per attached Dimension Sheet ☐5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet ☐6 JL 09/11/30

110 0.00

Mill Conv

CONVENTIONAL MILLING MACHINE

Conventional Milling Machine

0.00

**Memo**

Machine Keyway and inspect per attached dimension sheet JL 09/11/30

120 QC2- Inspect parts off machine FAI/FAIB 0.00

QC

Quality Control

JL 09/11/30

0.00

**Memo**

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**Start Date:** 15/10/2009 **Start Qty:** 6.00 **Cust Item ID:**

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**Run Start** **Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | QC8- Inspect parts - second check | 0.00 | | | | 6 | 0 | | |
| QC | | | SP 09/11/30 | | | | | | |
| Quality Control | **Memo** | 0.00 | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| HandFinish | | | NWD 09/11/30 | | | | | | |
| Hand Finishing | **Memo** | 0.00 | | | | | | | |
| 150 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| Powdercoat | M1112148 | | | | | | | | |
| Powder Coating | **Memo** | 0.00 | | | | | | | |
| | START TIME: 1:45 ☐OVEN TEMPERATURE: 320 ☐FINISH TIME: 2:15 | | BR 09-11-30 | | | (6). | | | |

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**Item Name:** Saddlle, RH Fwd Aft In 206

**Start Date:** 15/10/2009 **Start Qty:** 6.00 **Cust Item ID:**

**Required Date:** 27/10/2009 **Req'd Qty:** 6.00 **Customer:**

**Reference:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 160 | QC3- Inspect Part Finish | 0.00 | MF 09/12/01 | | | X6 | 9 | | |
| QC Quality Control | **Memo** | 0.00 | | | | | | | |
| 170 | Identify as per dwg & Stock Location: ST426 | 0.00 | | | | 09/12/01 | 6 | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | 09/12/01 MF | |
| QC Quality Control | **Memo** | 0.00 | | | | | | | |

MF
09-12-01

# Picklist Print



*October 15, 2009 12:37:04 PM*

**Work Order ID:** 52845

**Parent Item:** D2666-2RevD

**Parent Item Name:** Saddlle, RH Fwd Aft In 206

**Comments:**

**Start Date:** 15/10/2009 **Required Date:** 27/10/2009

**Start Qty:** 6.00 **Required Qty:** 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D6101-001RevB | | Manufactured | No | | | 100 | Each | 0.0000 | 6.0000 | | | |
| Saddle Billet | | | | | | | | | | | | |

B 46409 JL 09/11/29

| DART AEROSPACE LTD | Work Order: | 52545 |
|---|---|---|
| | | |
| **Description:** 206 Saddle, Inboard, Right side | Part Number: | D2666-2 |
| | | |
| **Inspection Dwg:** D2666 Rev. D | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.100 | 0.140 | | .125 | .122 | .123 | .122 | | |
| B | 0.100 | 0.140 | | .119 | .119 | .119 | .119 | | |
| C | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | | |
| D | 0.100 | 0.180 | | .130 | .130 | .130 | .130 | | |
| E | 0.210 | 0.230 | | .222 | .220 | .220 | .220 | | |
| F | 1.313 | 1.343 | | 1.326 | 1.325 | 1.325 | 1.324 | | |
| G | 0.240 | 0.260 | | .255 | .251 | .251 | .252 | | |
| H | 0.615 | 0.685 | | .650 | .650 | .650 | .650 | | |
| I | 1.125 | 1.145 | | 1.133 | 1.134 | 1.135 | 1.134 | | |
| J | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | | |
| K | 0.235 | 0.240 | | .238 | .238 | .238 | .238 | | |
| L | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | | |
| M | 0.100 | 0.120 | | .113 | .113 | .113 | .114 | | |
| N | 1.565 | 1.585 | | 1.573 | 1.574 | 1.575 | 1.574 | | |
| O | 5.990 | 6.010 | | 6.002 | 6.002 | 6.002 | 6.002 | | |
| P | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| R | 0.490 | 0.510 | | .498 | .498 | .499 | .498 | | |
| S | 0.313 | 0.318 | | .314 | .314 | .314 | .314 | | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| U | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | | |
| V | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | | |
| W | 0.540 | 0.560 | | .549 | .551 | .550 | .550 | | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | | |
| Y | 0.257 | 0.262 | | .258 | .258 | .258 | .258 | | |
| Z | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| Measured by: | JL |
|---|---|
| Date: | 09/11/29 |

| Audited by | |
|---|---|
| Date: | 09/11/30 |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.06.30 | Dimension revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |

| DART AEROSPACE LTD | Work Order: | 52545 |
|---|---|---|
| | | |
| **Description:** 206 Saddle, Inboard, Right side | Part Number: | D2666-2 |
| | | |
| **Inspection Dwg:** D2666 Rev. D | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Dim | Min | Max | Go/No Go Gauge | #5 | #6 | #8 | #4 | By | Date |
| A | 0.100 | 0.140 | | .121 | .122 | | | | |
| B | 0.100 | 0.140 | | .119 | .120 | | | | |
| C | 2.470 | 2.510 | | 2.490 | 2.490 | | | | |
| D | 0.100 | 0.180 | | .130 | .130 | | | | |
| E | 0.210 | 0.230 | | .220 | .219 | | | | |
| F | 1.313 | 1.343 | | 1.325 | 1.325 | | | | |
| G | 0.240 | 0.260 | | .252 | .250 | | | | |
| H | 0.615 | 0.685 | | .650 | .650 | | | | |
| I | 1.125 | 1.145 | | 1.135 | 1.135 | | | | |
| J | 0.990 | 1.010 | | 1.000 | 1.000 | | | | |
| K | 0.235 | 0.240 | | .238 | .238 | | | | |
| L | 0.510 | 0.515 | | .512 | .512 | | | | |
| M | 0.100 | 0.120 | | .113 | .113 | | | | |
| N | 1.565 | 1.585 | | 1.575 | 1.575 | | | | |
| O | 5.990 | 6.010 | | 6.002 | 6.002 | | | | |
| P | 1.245 | 1.255 | | 1.250 | 1.250 | | | | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | | | | |
| R | 0.490 | 0.510 | | .501 | .500 | | | | |
| S | 0.313 | 0.318 | | .314 | .314 | | | | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | | | | |
| U | 1.357 | 1.367 | | 1.362 | 1.362 | | | | |
| V | 0.315 | 0.322 | | .316 | .316 | | | | |
| W | 0.540 | 0.560 | | .550 | .550 | | | | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | | | | |
| Y | 0.257 | 0.262 | | .258 | .258 | | | | |
| Z | 0.178 | 0.198 | | .188 | .188 | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| Measured by: | SL |
|---|---|
| Date: | 09/11/30 |

| Audited by | SF |
|---|---|
| Date: | 09/11/30 |

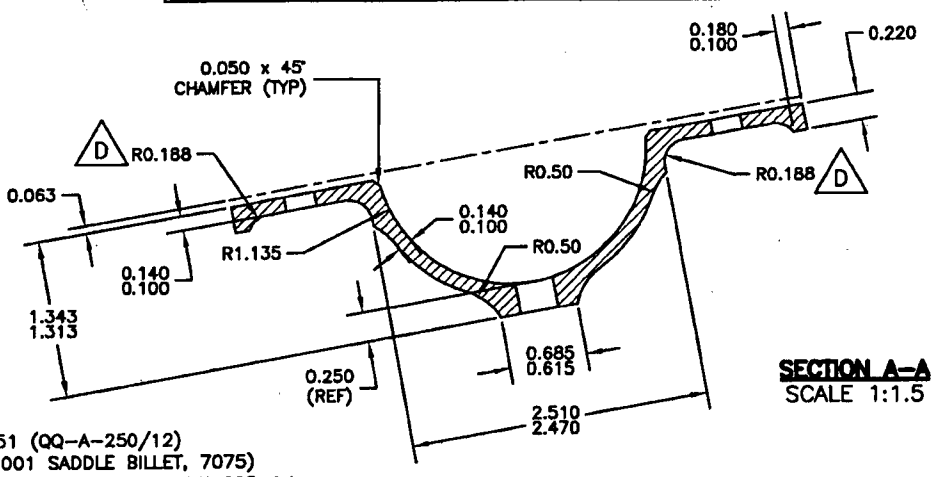
| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.06.30 | Dimension revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, WA |
|---|---|---|
| CHECKED PH | APPROVED | DRAWING NO. D2666 REV. D SHEET 1 OF 1 |
| DATE 06.11.08 | | TITLE SADDLE FWD INSIDE HIGH SCALE 1:3 |

| | | |
|---|---|---|
| A | 97.03.25 | NEW ISSUE |
| B | 97.07.11 | ANGLE AND NOTES ADDED |
| C | 06.05.26 | INCORPORATE DEO 9122, 9102, 9095 |
| D | 06.11.08 | R0.188 WAS R0.30; ø0.316 WAS ø0.313 |

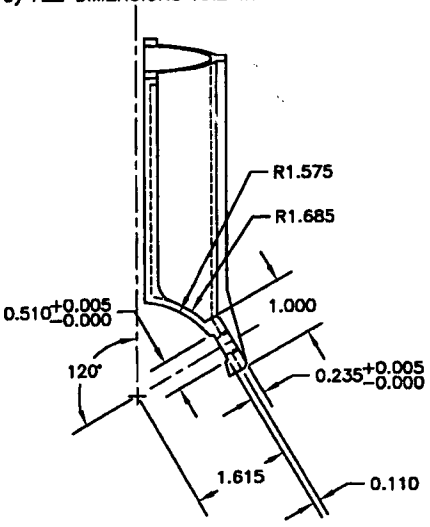
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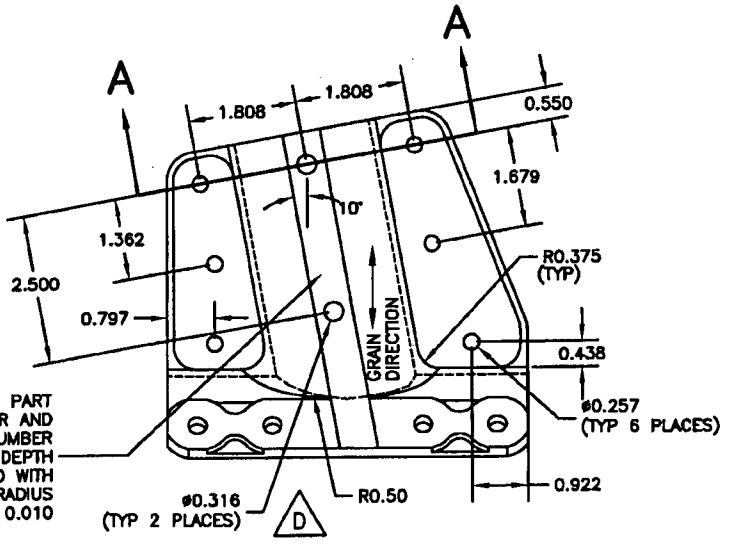
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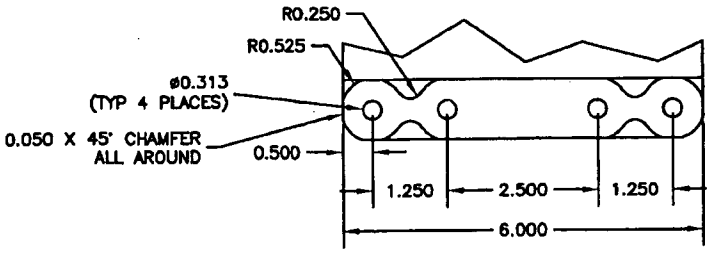



SECTION A–A
SCALE 1:1.5

NOTES:
1) MATERIAL: ALUMINUM 7075–T7351 (QQ–A–250/12)
(MAKE FROM D6101–001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) D2666–1 SHOWN (D2666–2 IS OPPOSITE)
6) ALL DIMENSIONS ARE IN INCHES




D2666–1 SADDLE FWD INSIDE HIGH

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